

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022727**Date Inspected:** 14-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N / A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued the review of informal welding report package #54. The QAI noted that the NDT reports in this package are missing the WQCM's signature and stamp that indicate a they have been reviewed.

The QAI was requested to sample partially threaded studs that will be supplied to the contractor for use in replacing the bike path panel mounting studs. The QAI conferred with the Structural Materials Representative (SMR) Bahjat Dagher in a effort to identify the contract specifications for the replacement studs. The QAI noted that according to Contract Change Order (CCO) 186, the contractor is allowed to use material conforming to ASTM A108 grade C1018 in lieu of ASTM A307. The QAI traveled to Stud Welding Products and met with Jesse Santos. The QAI was given a copy of the Certificate of Compliance (COC) with the material specifications for the intended replacement studs. The QAI noted that the available documentation describes the materials as ASTM A108 grade C1015. The QAI asked Mr. Santos if there were any other documents available that identify the material specifications for the replacement studs that have been ordered by the contractor. The QAI was provided with the purchase order and noted that it did not appear to specify a grade of material. The QAI notified the SMR and was informed that since the QAI is present at Stud Welding Products, the necessary check samples should be pulled. The QAI was informed that the contractor will be notified of the apparent material substitution. The QAI assigned lot number B212-005-11 to the samples that were taken. See the attached photo. The SMR

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informed the QAI that the samples will not be tested until the material suitability / specifications are determined to be acceptable.



Summary of Conversations:

The QAI relayed the status of document reviews to the QAI Lead Bill Levell. The QAI also had conversations regarding the sampling and material grade of the partially threaded studs, as described above. There were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
